

DART AEROSPACE LTD		Work Order:	10860
Description: BRACKET MODIFICATION		Part Number:	DEO 9251
Dwg: DEO 9251 Rev. A		Qty:	16
		Page 1 of 1	

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveller	12	03.02.20	16
2	MU	Machine bracket per DEO 9251 and Folio FA319	ST	03/02/20	15
3A	QC2	Inspect parts as they come off the CNC machine	ST	03/02/20	16
4	MU	Deburr as required	ST	03/02/20	15
5	QCS	Inspect work to step 4	ST	03/02/21	16
6	PF	Powder coat white Gloss (4.3.5.1) per QSI 005 4.3 <del>(REMOVE PRIME &amp; PAINT FIRST)</del>	ST	03.02.25	16
7	QCS	Inspect powder coat	ST	03.02.26	16
8	ST	Identify and stock as DEO 9251	ST	03-02-26	16
9	AC	Cost/part: £81.6K CHANGE TO Kwik Fast Inventory	ST	03-02-27	-
10	DC	Close w/o Inspect level 21	ST	03.02.27	-
3B	MU	OPEN HOLES (ø0.375) TO ø0.391 (25/64) (4 PLACES)	ST	03/02/24	

Rev	Date	Change	Revised By	Approved
A	03.02.20	New issue	ST	ST



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. DEO 9251	REV. A SHEET 1 OF 1
DATE 03.02.19		TITLE BRACKET MODIFICATION	SCALE NTS
A	03.02.19	NEW ISSUE	

## DART ENGINEERING ORDER

TO AMEND BHA/DRA/358-02-01 REV. F

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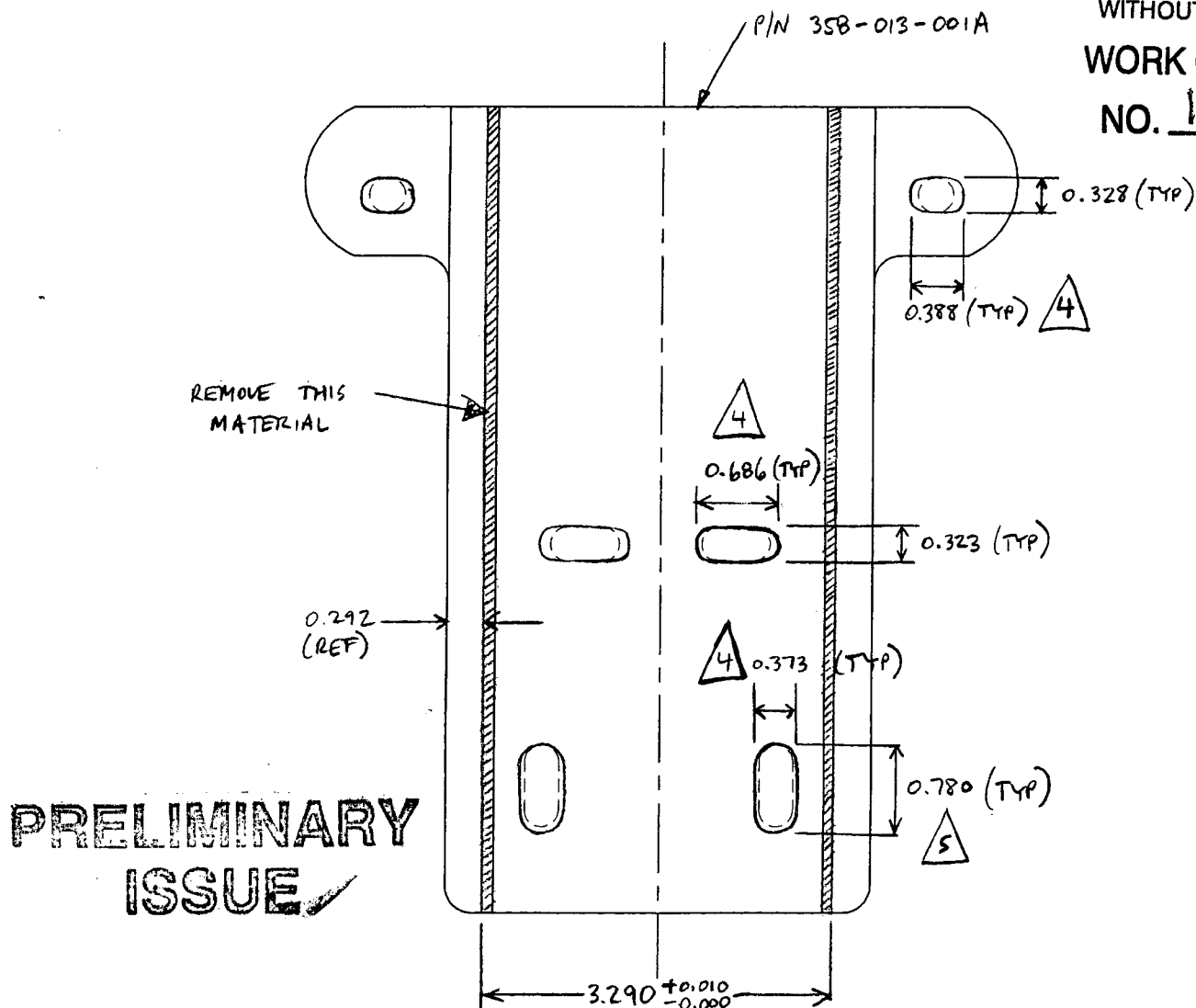
RETURN TO  
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SUBJECT TO AMENDMENT  
WITHOUT NOTICE

WORK ORDER

NO. 18860



PRELIMINARY  
ISSUE ✓

- NOTES:
- 1) IDENTIFY AS DEO 9251-1 AFTER MODIFICATION
  - 2) POWDER COAT WHITE (4.3.5.1) PER QSI 005 4.3 AFTER MODIFICATION
  - 3) ALL SLOT DIMENSIONS ARE  $\pm 0.010 / -0.000$
  - 4) ADD 0.030 TO EACH SIDE OF EXISTING HOLE OR SLOT TO GET THIS DIM
  - 5) ADD 0.030 TO BOTTOM SIDE TO GET THIS DIM

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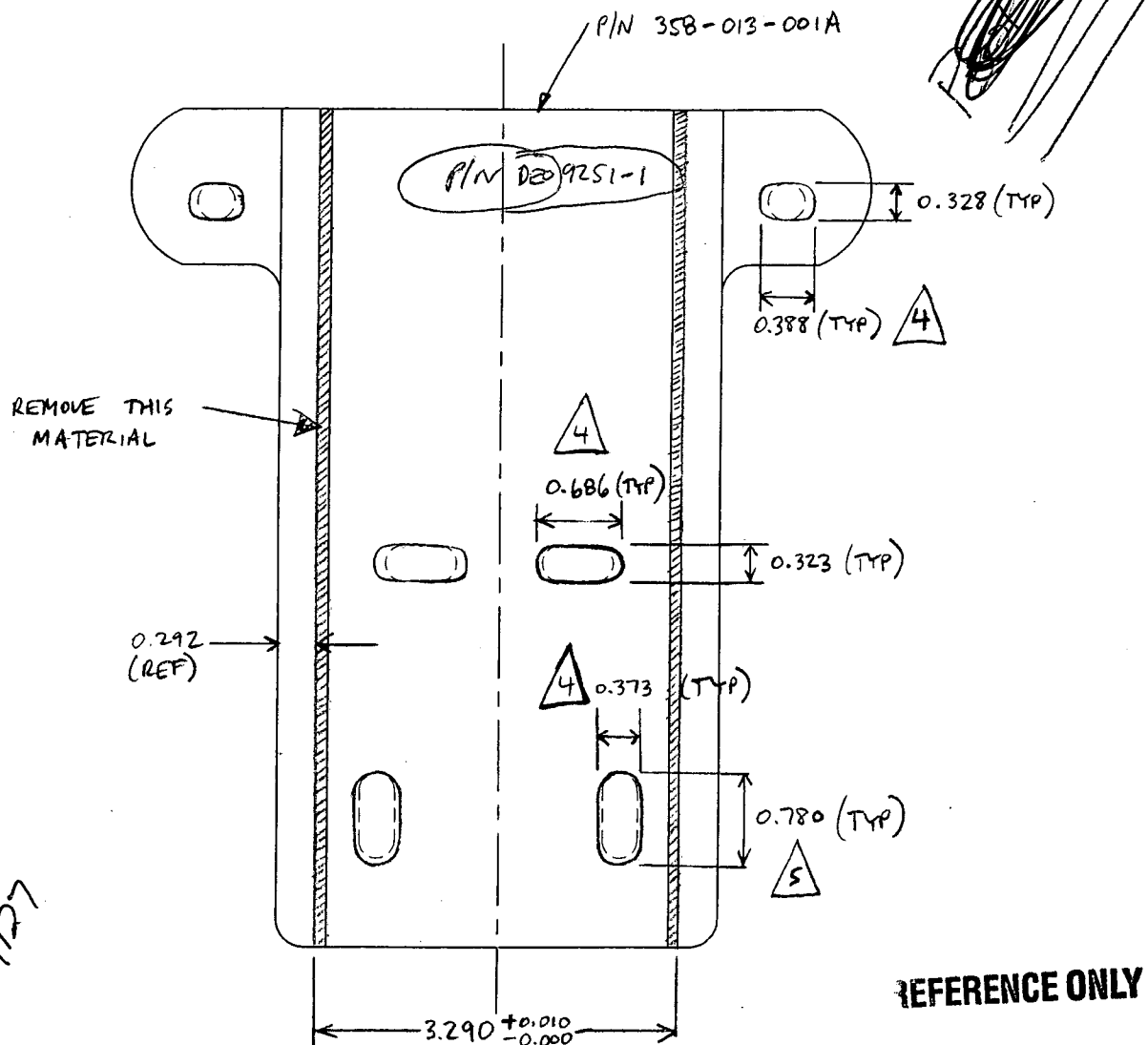


DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. DEO 9251	REV. A SHEET 1 OF 1
DATE 03.02.19		TITLE BRACKET MODIFICATION	SCALE NTS
A	03.02.19	NEW ISSUE	

## DART ENGINEERING ORDER

TO AMEND BHA/DRA/358-02-01 REV. F

FAB19



- NOTES:
- 1) IDENTIFY AS DEO 9251-1 AFTER MODIFICATION
  - 2) POWDER COAT WHITE (4.3.5.1) PER QSI D05 4.3 AFTER MODIFICATION
  - 3) ALL SLOT DIMENSIONS ARE  $+0.010/-0.000$
  - 4) ADD 0.030 TO EACH SIDE OF EXISTING HOLE OR SLOT TO GET THIS DIM
  - 5) ADD 0.030 TO BOTTOM SIDE TO GET THIS DIM

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Supplier Code: \_\_\_\_\_ Sheet \_\_\_\_ of \_\_\_\_

### INSPECTION CHECKLIST

PART NO.: DEO 9251 PHY. CHANGE: \_\_\_\_\_  
DESCRIPTION: Bracket Modification DRAWING CHANGE: REV. A  
MANUFACTURING DATE: 03/02/20 UNICORP E.O.'S: \_\_\_\_\_  
BATCH NO.: 18860 \_\_\_\_\_  
SERIAL NO.: \_\_\_\_\_ PURCHASE ORDER NO.: \_\_\_\_\_  
QUANTITY ACCPT. \_\_\_\_\_ REJ. \_\_\_\_\_ DATA SHEET NO.: \_\_\_\_\_

☒ FIRST ARTICLE ☐ PERIODIC CONFORMITY ☐ FINAL INSPECTION

ITEM	DWG PAGE	DRAWING DIMENSION	TOL.	ACTUAL DIMENSION	ACC.	REJ.	% OF INSP.	Method of Inspection	Comments
1	1	3.278	±0.010	3.31	✓		100%	11	
1	1	3.388	"	3.388	✓			"	
1	1	3.33	"	3.34	✓			"	
1	1	6.86	"	6.86	✓			"	
1	1	3.33	"	3.31	✓			"	
1	1	3.80	"	3.81	✓			"	
1	1	3.290	"	3.275	✓	✓		"	OK
1	1	3.290	±0.008	3.290	✓			"	
NOTE: ① ON SECOND PART LH SLOT IS 0.955 INSTEAD OF 0.780 THIS WILL NOT AFFECT THE DESIGN 03.02.21									
② TO BRING QTY BACK TO 16, ONE OF THE PROTOTYPE PARTS (DONE BY HAND) WAS MADE INTO PRODUCTION PART. ONLY PROBLEM WITH THIS PART IS THAT SLOTS ON RHS ARE BIGGER THAN PER DEO 9251. INSTALL ON LHS ONLY 03.02.21									

H:\admin-qalis\forms\first article inspectionA

Rev. B

Measured by: SP

Audited by: EC

Approved by: 03.02.20

Work Order:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Manuf / Design Mgr	Approval QC Inspector

NCR		WORK ORDER NON-CONFORMANCE						
DATE	STEP	Description of NC section A	Corrective Action Section B		Sign & Date	Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial					
03/03/24	2	Origin was not taken at the right place .100" difference						

PAR#: \_\_\_\_\_ Fault Category: \_\_\_\_\_ DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries  
H:\Admin-QA\ISO\forms\w\oncB.doc

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_